Work Order ID 101537

May-13-13 1:04:16 PM

101537

Item ID: D2654-3
Revision ID:
Item Name: Web

Accept *N900040100*

Setup **Start** *NS1*
Stop *NS2*

Start Date: 5/13/13 **Start Qty:** 2.00 *2*
Required Date: 5/31/13 **Req'd Qty:** 2.00 *2*
Reference:

Cust Item ID:
Customer:

Run **Start** *NR1*
Stop *NR2*

Approvals: **Process Plan:** MCJ **Date:** 13-05-16 **Tooling:** ______ **Date:** ______
QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D2654	**Revision Nbr** F								
100 *100* Skidtubes Skidtubes	Skidtubes	0.00							
	Memo 1-Cut D2600-5 to length as per Dwg D2654 2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654 3-Using the uni-bit, open holes to finish size as per Dwg D2654 4-Deburr holes and ends	0.00	J.D		13/7/15		2		
110 *110* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00			DAS 03 8-89	DP	13-7-15		
	Memo	0.00							
120 *120* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00	J.D	13/7/15					
	Memo	0.00							

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ____________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 101537 *101537*

May-13-13 1:04:16 PM

Item ID: D2654-3 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Web

Start Date: 5/13/13 **Start Qty:** 2.00 *2* **Cust Item ID:**

Required Date: 5/31/13 **Req'd Qty:** 2.00 *2* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC7-Inspect Chemical Conversion Coat	0.00				2			BB 13/07/17
	Memo	0.00							
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: LG	0.00							B 13/07/17
	Memo	0.00							
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00				MCJ 13-07-18			
	Memo	0.00							

MCJ 13-07-18

#

DQA: ______ Date: ______

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______ Part No. ______ NCR No. ______	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ______
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		______
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		______
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		______
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

May-13-13 1:04:16 PM

Work Order ID: 101537

Parent Item: D2654-3

Parent Item Name: Web

Start Date: 5/13/13 **Required Date:** 5/31/13

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedure DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108 Extrusion `I Beam' thin		Manufactured	No			100	Each	91.0000	1	2			

Location		Loc Qty	Loc Code
LG		91	
	73909	2	
	90684	89	

2 JD 13/7/15

DQA: ________ Date: ________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

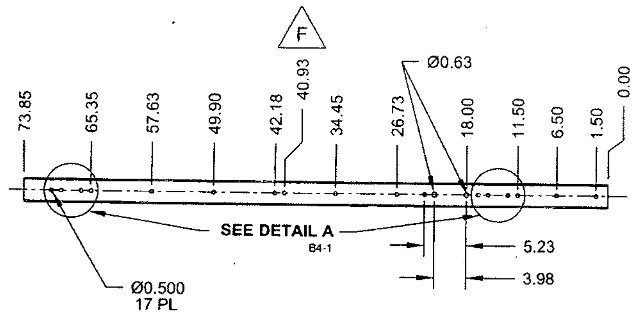
QA Closed: Date:

Work Order / Part / NCR	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Work Order: ________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Part No. ________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
NCR No. ________	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

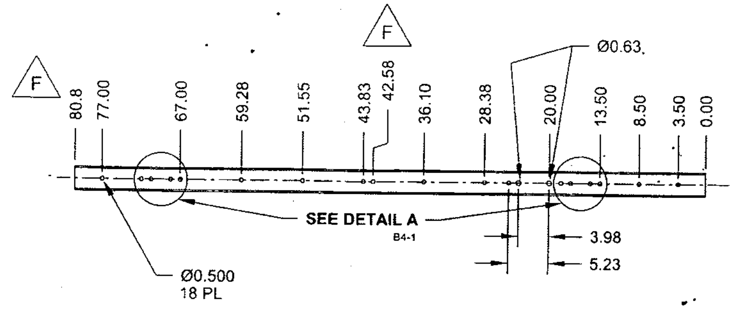
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

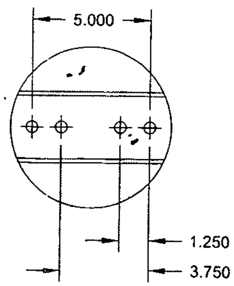
Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		



D2654-1 WEB



D2654-3 WEB



DETAIL A

C2-1
C3-1
C6-1
C8-1
D3-2
D6-2
B3-2
B6-2

RELEASED 2011-09-12

101537 MCS
130516

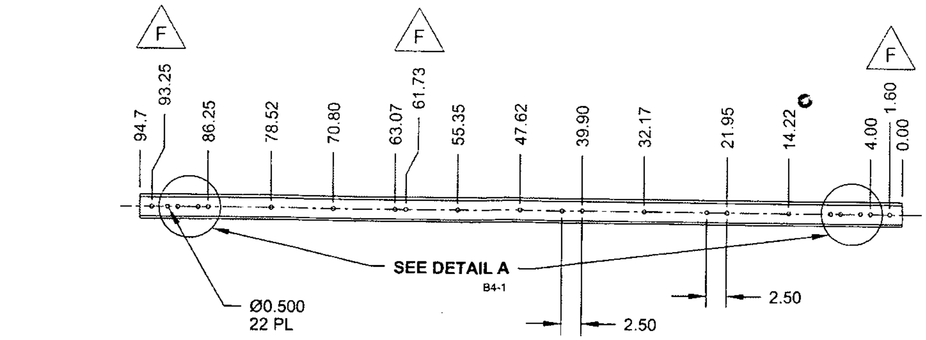
NOTES:

1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

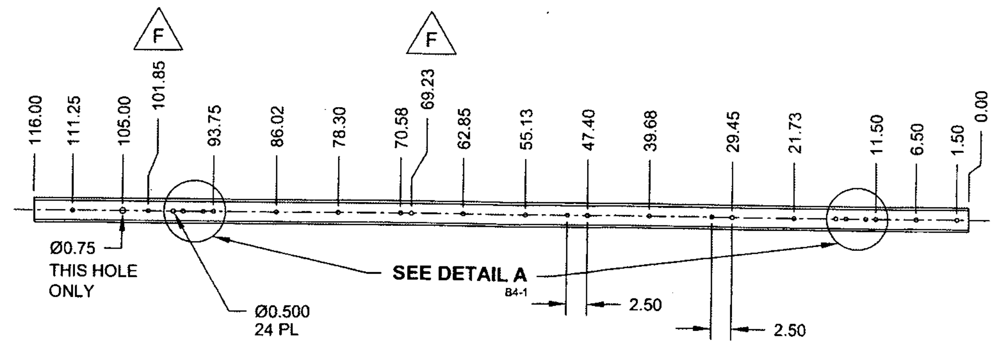
REV.	DESCRIPTION	BY	DATE
F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2	SC	11.05.05
E	CHANGE LENGTHS, REFORMAT	CP	04.05.26
D	GHW HOLES CHANGED TO Ø0.63	CP	98.01.15
C	CHANGED HOLE PATERN	CP	97.10.29
B	ALTER HOLE PATERN, 0.500 WAS 0.438	CP	97.06.26
A	NEW ISSUE	CP	97.03.25

DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA
DRAWN	SC	
CHECKED	[signature]	DRAWING NO. D2654 — REV. F — SHEET 1 OF 2
MFG. APPR.	[signature]	
APPROVED	[signature]	TITLE WEB — SCALE NTS
DE APPR.	[signature]	
DATE	11.05.05	

#10537



D2654-5 WEB



D2654-7 WEB

RELEASED 2011-09-12

DESIGN	CP	**DART AEROSPACE USA, INC** PORT HADLOCK, WA
DRAWN	SC	
CHECKED	[signature]	DRAWING NO. D2654 — REV. F, SHEET 2 OF 2
MFG. APPR.	[signature]	
APPROVED	[signature]	TITLE WEB — SCALE NTS
DE APPR.	[signature]	
DATE	11.05.05	